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D3147-1
Job Sheet 202239



Part No: D3147-1

Job Qty: 6 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev A New Issue 07-01-26 JLM IPP Rev:B Now on Cnc 07-05-02 JLM IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	6 pcs	11/1/19	11/1/19	1.00	2.07	Doosan - 1		
110	QC 2	6 pcs	11/1/19	0.00	0.00		QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S228906



Part: D3147-1

Job No: 202239

Serial No/Batch: S228906

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/01/19

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120 QC 8	6 pcs	11/1/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	an 19/11/04
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	6 pcs	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	CA002 5 nov 19 JA
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	D&S
				Packaging 3 - 26 - B4B	21
140 QC 21 - SA	6 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	9-59 NOV 0-5-2019

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Doosan Lathe) 1-TURN AS PER FOLIO FA691 & DWG D3147 ,
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.187	M303R0.125	1.3500 ft (.225 ea) <i>1.5/6</i>	100-Doosan - 1	<i>M127864</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.187	1	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Pin	2.500inches ± 0.010	2.510 2.490	<i>2.499</i>	
2	Pin	0.200inches ± 0.010	0.210 0.190	<i>.199</i>	
3	Pin	5.000Degrees ± 0.500	5.500 4.500	<i>5.5</i>	
4	Pin	0.080inches ± 0.030	0.110 0.050	<i>.082</i>	Radius
5	Pin	0.010inches ± 0.010	0.020 0.000	<i>.012</i>	Radius
6	Pin	0.125inches + 0.004 - 0.001	0.129 0.124	<i>.127</i>	Diameter
7	Pin	0.150inches ± 0.010	0.160 0.140	<i>.15</i>	
8	Pin	0.090inches ± 0.030	0.120 0.060	<i>.095</i>	Radius
9	Pin	0.200inches ± 0.010	0.210 0.190	<i>.200</i>	
10	Pin	0.181inches ± 0.010	0.191 0.171	<i>.187</i>	Diameter
11	Pin	0.620inches ± 0.010	0.630 0.610	<i>.623</i>	
12	Pin	0.111inches ± 0.010	0.121 0.101	<i>.110</i>	
13	Pin	0.010inches ± 0.030	0.040 (0.020)	<i>.02</i>	Radius

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SCRAP 1/60



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRR (QS1042)	
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition			
Description Work Order Deviation				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details: _____					